

DQA:

Date:



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
			Rework Scrap Use-as-is Suspected Unapproved	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other				
Part No. _____											
NCR No. _____											
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Design											
Doc/Data											
Equip/Tooling											
Handling/Pre											
Material											
Operator											
Offset/Setup											
Process											
Supplier											
Training											
Transport											
Unapproved											
FAULT CATEGORY											
Landing Gear			General								
Bending	Bend		Folio/Program		Outside Dimensions		Pressure/Forced				
Centre Not Concentric	BOM/Route		Grain		Over/Under tolerance		Set-up				
Cracks	Broken/Damage/Defect		Hardware		Part Incorrect		Temperature/Cure				
Crimp/Kink/Ripple/Wave	Burrs		Inspection Incomplete/Unqualified		Part Lost/Missing		Weld				
Cuffs	Contamination		Instructions Incomplete/Unclear		Part Moved		Wrong Stock Pulled				
Crushing	Countersink		Misaligned/off center		Positioned Wrong						
Heat Treat	Cut Too Short		Mislabeled		Power Loss/Surge						
Inspection Strip in Tube	Drawing		Misread								
Marks/Chatter	Drill Holes		Off-set								
Turning Sequence	Finish		Out of Calibration								
Wave/Twist in Tube	Fit/Function		Out of Sequence								

Work Order ID 113648

February-24-14 10:00:36 AM

113648

Page 2

Item ID: D3589-047

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Fwd Guide

Stop

NS2

Start Date: 2/27/14 **Start Qty:** 4.00

4

Cust Item ID:

Required Date: 2/27/14 **Req'd Qty:** 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

**Sequence ID/
Work Center ID**

**Operation
Description**

**Set Up/
Run Hours**

Tool ID

Tool #

**Plan
Code**

**Accept
Qty**

**Reject
Qty**

**Reject
Number**

**Insp.
Stamp**

130

Identify as per dwg & Stock Location: _____

0.00

130

Packaging

Packaging

SO 056

0.00

*14/3/27 (Y) DAS
32 9-89*

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Quality Control

Memo

0.00

MLJ 14-03-27

MLJ 14-03-27

DQA:

Date:



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date:

Work Order update only

Work Order: _____
 Part No. _____
 NCR No. _____

DISPOSITION

Rework
Scrap
Use-as-is
Suspected Unapproved

AGAINST DEPARTMENT/PROCESS

Skid-tube
Machining
Thermoforming
Large Fab

Crosstube
Small Fab
Finishing
Composite

Water Jet
Prod. Eng. Coor.
Rec/Store/Packaging
Supplier

Engineering
Quality
Other

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function				<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence				<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled			
	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
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	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
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	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
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Picklist Print

February-24-14 10:00:36 AM

Page 1

Work Order ID: 113648

113648
D3589-047

Parent Item: D3589-047

Parent Item Name: Fwd Guide

Start Date: 2/27/14

Required Date: 2/27/14

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 08-05-30 new issue DD verified by:ec
12.07.23 AS PER REV.C DD VERF:EC

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3589-17 Manufactured No 100 Each 22.0000 1 4 **

D3589-17

Fwd Guide Plate

Location Loc Qty Loc Code

WA002 22

[104570] 22

D3589-5 Manufactured No 100 Each 66.0000 1 4 **

D3589-5

Latch Guide

Location Loc Qty Loc Code

WA001 16

103873 16

WA002 50

[107639] 12

108644 38

14-03-25

14-03-25

DQA:

Date:

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed:

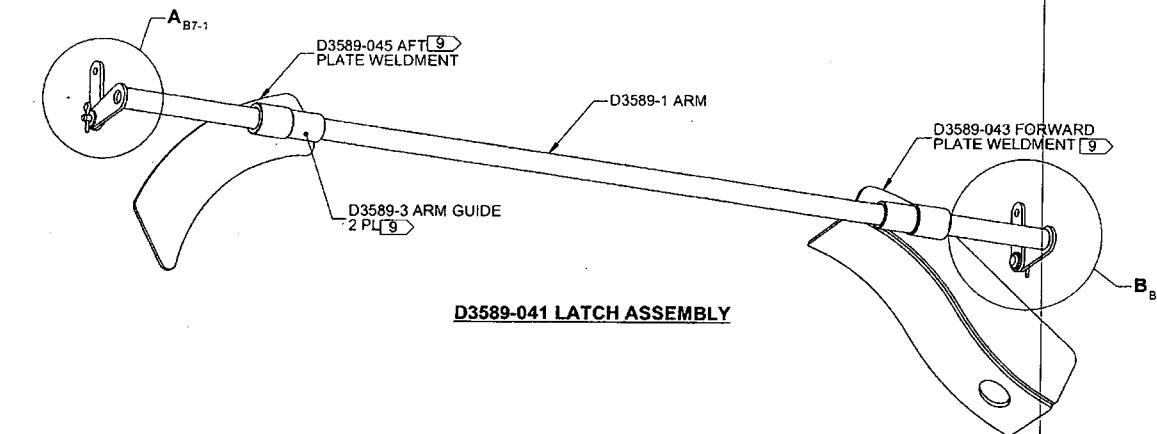
Date:

Work Order update only

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
			Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>				
Part No. _____			Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>				
NCR No. _____			Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>				
			Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>					
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Design											
Doc/Data											
Equip/Tooling											
Handling/Pre											
Material											
Operator											
Offset/Setup											
Process											
Supplier											
Training											
Transport											
Unapproved											
FAULT CATEGORY											
Landing Gear			General								
Bending		Bend		Folio/Program		Outside Dimensions		Pressure/Forced			
Centre Not Concentric		BOM/Route		Grain		Over/Under tolerance		Set-up			
Cracks		Broken/Damage/Defect		Hardware		Part Incorrect		Temperature/Cure			
Crimp/Kink/Ripple/Wave		Burrs		Inspection Incomplete/Unqualified		Part Lost/Missing		Weld			
Cuffs		Contamination		Instructions Incomplete/Unclear		Part Moved		Wrong Stock Pulled			
Crushing		Countersink		Misaligned/off center		Positioned Wrong					
Heat Treat		Cut Too Short		Mislabeled		Power Loss/Surge					
Inspection Strip in Tube		Drawing		Misread							
Marks/Chatter		Drill Holes		Off-set							
Turning Sequence		Finish		Out of Calibration							
Wave/Twist in Tube		Fit/Function		Out of Sequence							

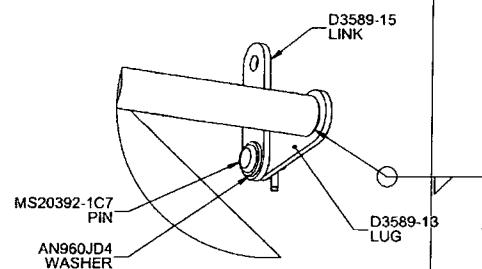
ITEM	QTY. -041	P/N	DESCRIPTION
X	D3589-041	LATCH ASSEMBLY	
1	1	D3589-043	FORWARD PLATE WELDMENT
2	1	D3589-045	AFT PLATE WELDMENT
3	1	D3589-1	ARM
4	2	D3589-3	ARM GUIDE
5	2	D3589-13	LUG
6	2	D3589-15	LINK
7	4	AN960JD4	WASHER
8	2	MS20392-1C7	PIN
9	2	MS24665-1010	COTTER PIN

D3589-041 LATCH ASSEMBLY



DETAIL A: LINK ASSEMBLY DETAIL D8-1

SCALE 2X
2 PL



DETAIL B: WELDING AND
LINK ASSEMBLY DETAIL C3-1

SCALE 2X
2 PL

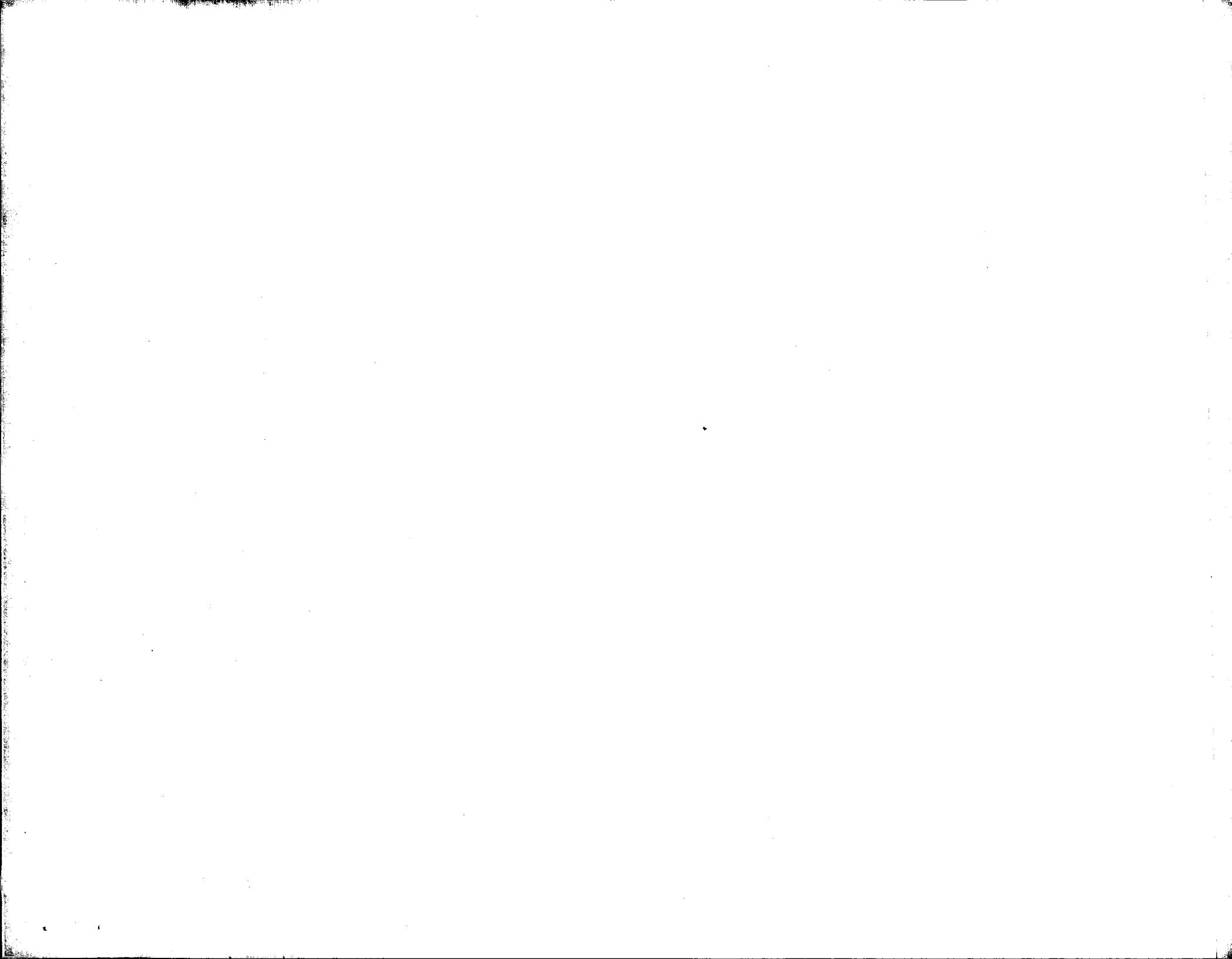
D3589-041 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3589-041" AND B/N "BXXXXX" PER DART QSI 044 6.1 (FINE POINT PAINT MARKER)
- 7) WEIGHT: 0.75 lbs
- 8) WELDING: PER DART QSI 004 USING DT9033
- 9) IDENTIFIED PARTS ARE LOOSE ON D3589-1 ARM
- 10) INSTALL COTTER PIN IN ACCORDANCE WITH MS33540

113648 MLJ
14-02-25

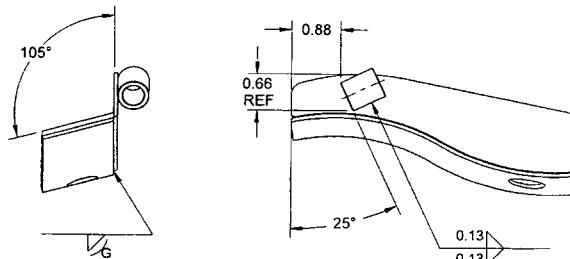
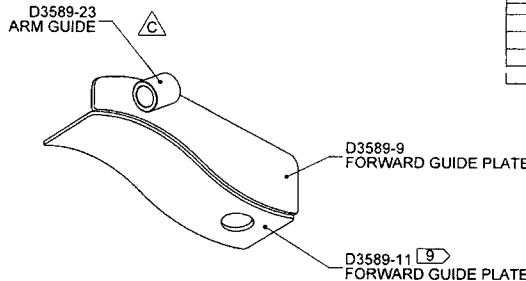
RELEASED
2012-07-16

C	REVISED D3589-5. 2.75 WAS 3.00 (ZN B6-4); ADDED D3589-21 (ZN B3-4). AFFECTS D3585-047 (ZN A7-3) AND D3589-041 (ZN A7-3). REVISED D3589-15. 0.140 WAS 0.012 (ZN C6-2). 0.200 WAS 0.172 (ZN C4-2). ADDED D3589-23 (ZN C5-4). AFFECTS D3589-043/045 (ZN D7-2 AND D2-2). REASON: PAR12-77.	MB	12.07.04
B	0.90 AND 0.63 REF WERE 1.97 AND 0.60 (ZN C6-2); 0.50 WAS 1.89 (ZN C3-2); 0.75 REF REPLACES 2.01 (ZN C2-2); 29° WAS 15° (ZN B2-2); 19.00 WAS 18.88 (ZN D4-4). REDESIGNED D3589-9 (ZN A6-6) AND D3589-11F (ZN C2-3) REASON: REDESIGN FOR PROPER FIT AND TO MATCH TESTED CONFIGURATION	MB	08.06.25
A	NEW ISSUE	MB	08.05.29
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3589	SHEET 1 OF 8
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	LATCH ASSEMBLY	NTS
DATE	12.07.04	COPYRIGHT © 2008 BY DART AEROSPACE LTD THE DOCUMENT CONTAINED HEREIN IS THE PROPERTY OF DART AEROSPACE LTD. IT IS TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

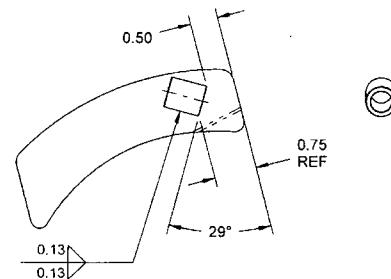
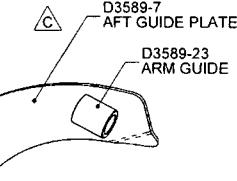


8 1 7 1 6 1 5 1 4 1 3 1 2 1

ITEM	QTY -043	QTY -045	P/N	DESCRIPTION
X		X	D3589-043	FORWARD PLATE WELDMENT
		X	D3589-045	AFT PLATE WELDMENT
1	1	1	D3589-7	AFT GUIDE PLATE
2	1	1	D3589-9	FORWARD GUIDE PLATE
3	1	1	D3589-11	FORWARD GUIDE PLATE
4	1	1	D3589-23	ARM GUIDE



D3589-043 FORWARD PLATE WELDMENT



D3589-045 AFT PLATE WELDMENT

D3589-043/045 NOTES:

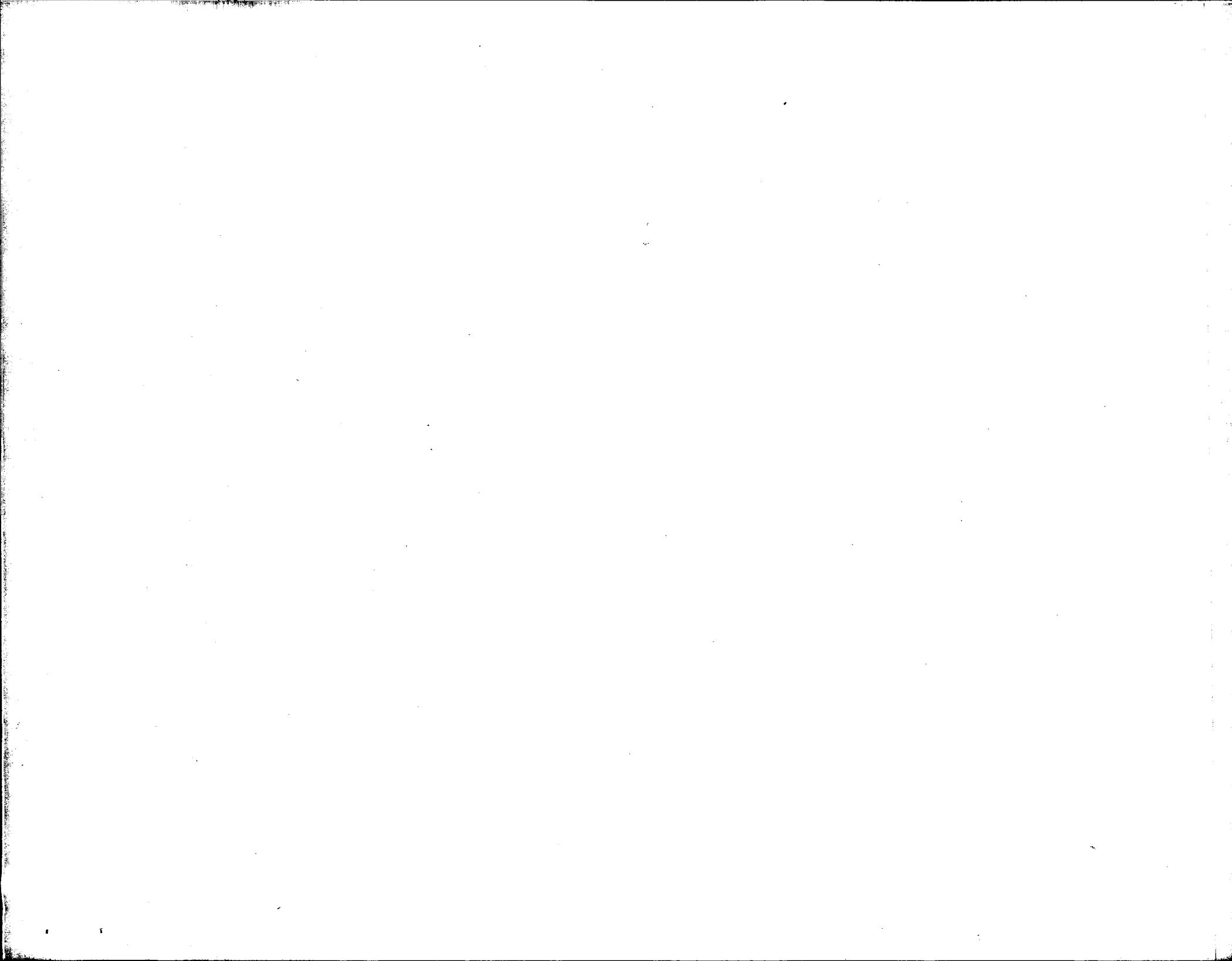
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT:
 - D3589-043 = 0.23 lbs
 - D3589-045 = 0.10 lbs
- 8) WELDING: PER DART QSI 004 USING DT9033
- 9) FORM D3589-11 TO FIT D3589-9 MATING EDGE

8 1 7 1 6 1 5 1 4 1 3 1 2 1

DESIGN	<i>b1</i>	DART AEROSPACE LTD
DRAWN	<i>b2</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>b3</i>	REV. C
MFG. APPR.	<i>b4</i>	DRAWING NO. D3589
APPROVED	<i>b5</i>	REV. C
DE APPR.	<i>b6</i>	SHEET 2 OF 8
DATE	12.07.04	TITLE LATCH ASSEMBLY
		SCALE NTS

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2012-07-16
[Signature]

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8

7

6

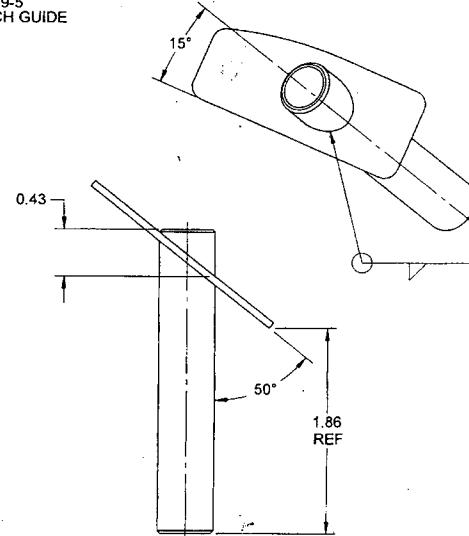
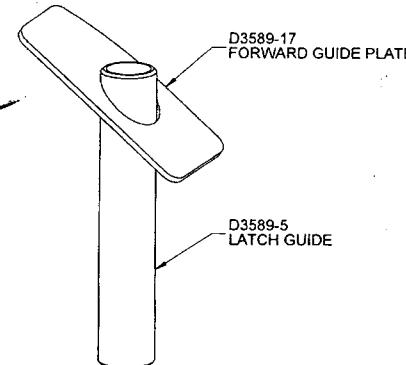
5

4

3

2

1

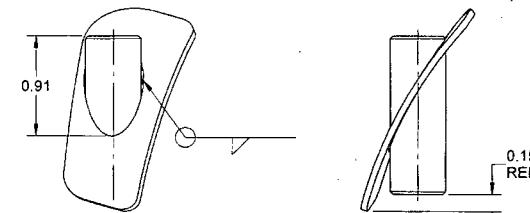
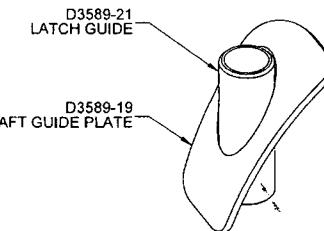


D3589-047 FORWARD GUIDE

D3589-047/-049 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT:
 - D3589-047 = 0.08 lbs
 - D3589-049 = 0.05 lbs
- 8) WELDING: PER DART QSI 004

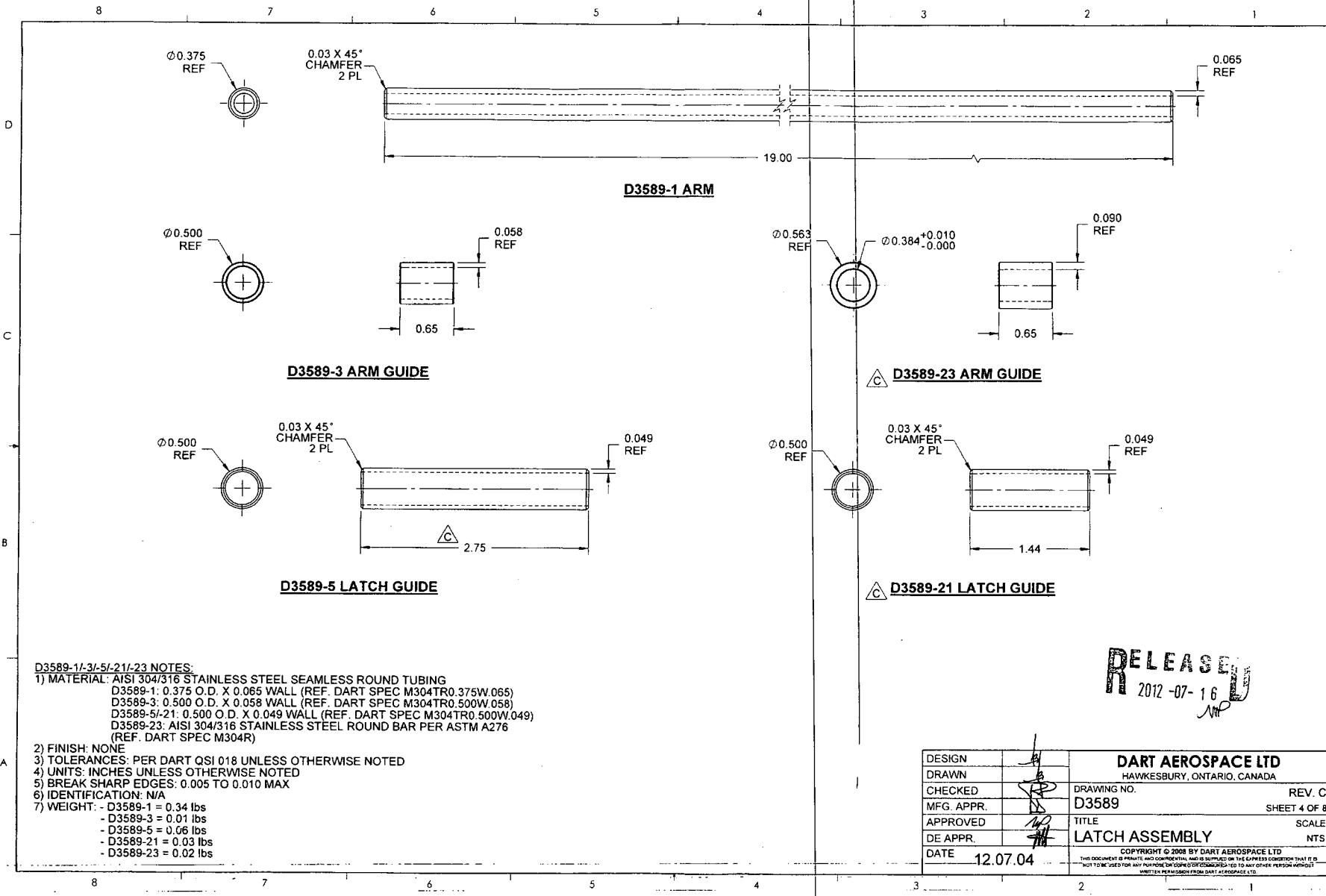
ITEM	QTY -047	QTY -049	P/N	DESCRIPTION
	X		D3589-047	FORWARD GUIDE
		X	D3589-049	AFT GUIDE
1	1		D3589-5	LATCH GUIDE
2	1		D3589-17	FORWARD GUIDE PLATE
3		1	D3589-19	AFT GUIDE PLATE
4		1	D3589-21	LATCH GUIDE



D3589-049 AFT GUIDE

RELEASED
2012-07-16
[Signature]

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	DRAWING NO. REV. C
MFG. APPR.	<i>[Signature]</i>	D3589 SHEET 3 OF 8
APPROVED	<i>[Signature]</i>	TITLE SCALE
DE APPR.	<i>[Signature]</i>	LATCH ASSEMBLY NTS
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RELEASED
2012-07-16
[Signature]

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	DRAWING NO. REV. C
MFG. APPR.	<i>[Signature]</i>	D3589 SHEET 4 OF 8
APPROVED	<i>[Signature]</i>	TITLE SCALE
DE APPR.	<i>[Signature]</i>	LATCH ASSEMBLY NTS
DATE	12.07.04	COPYRIGHT © 2008 BY DART AEROSPACE LTD
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8 7 6 5 4

3 2 1

D

D

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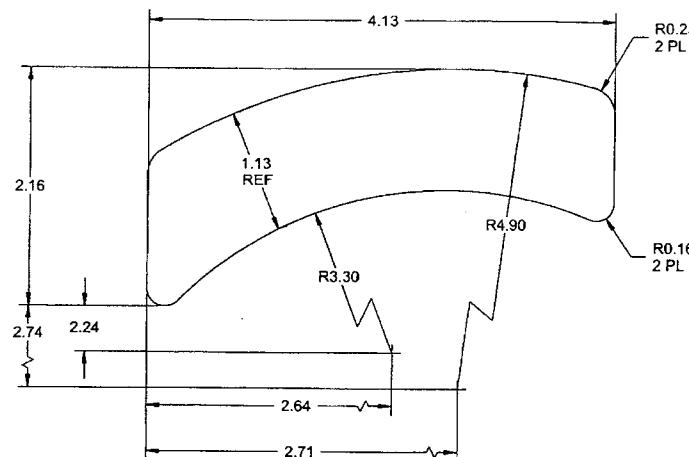
C

B

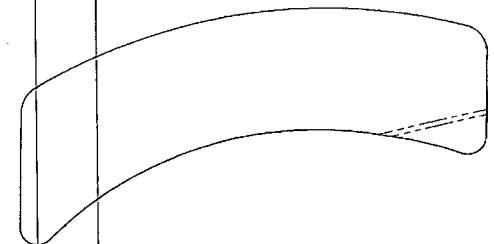
B

A

A



**D3589-7F AFT GUIDE PLATE
FLAT PATTERN**



**D3589-7 AFT GUIDE PLATE
MAKE FROM D3589-7F**

RELEASED
2012-07-16
W

D3589-7/-7F NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, PER AMS 5513 OR AMS 5524, OR MIL-S-5059 (ANNEALED) 2B FINISH, 16 GAUGE (0.063 THICK), (REF. DART SPEC M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.09 lbs

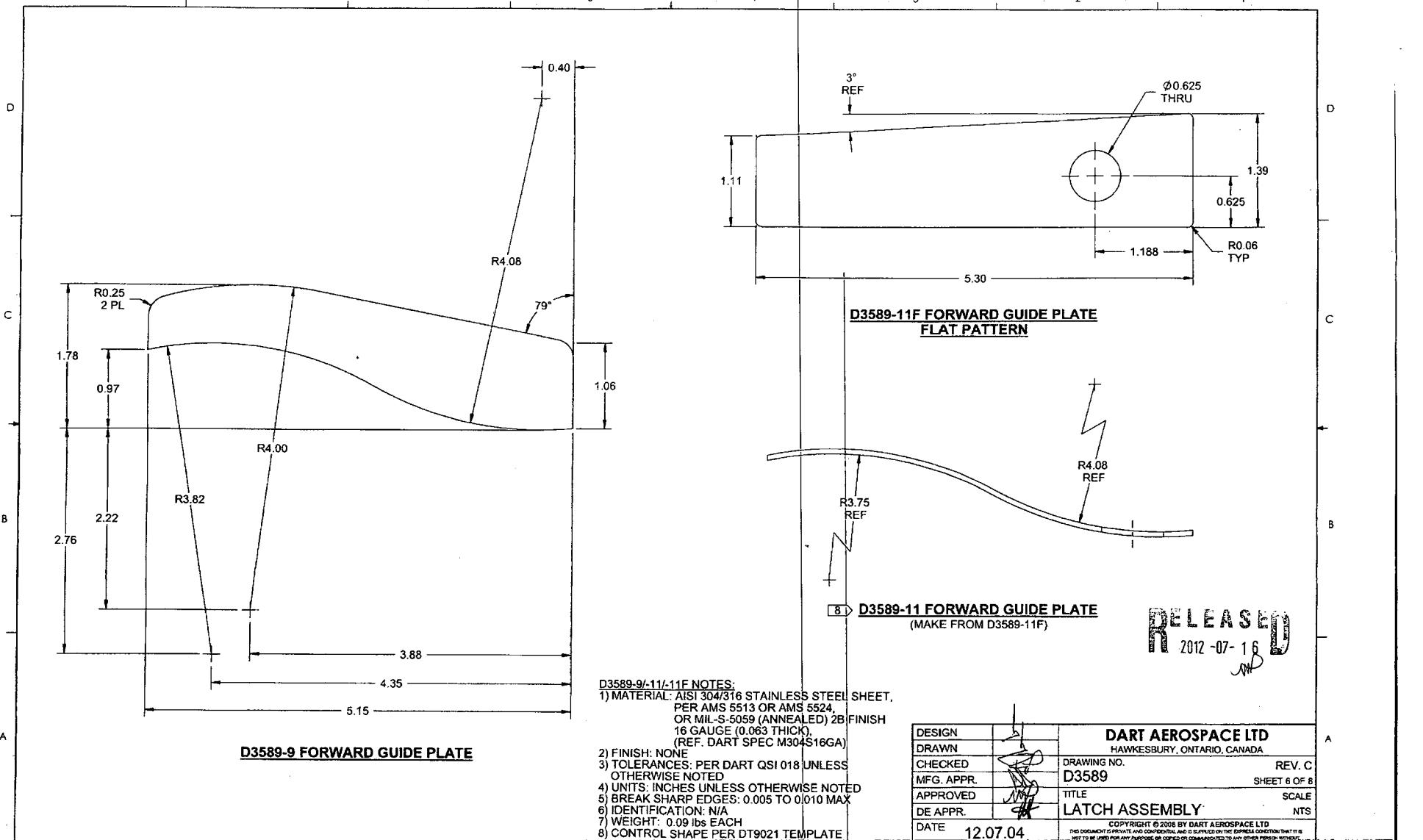
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DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	REV. C
MFG. APPR.		D3589
APPROVED	<i>[Signature]</i>	SHEET 5 OF 8
DE APPR.	<i>[Signature]</i>	TITLE
DATE	12.07.04	SCALE
		NTS

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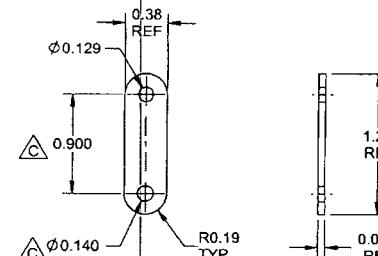
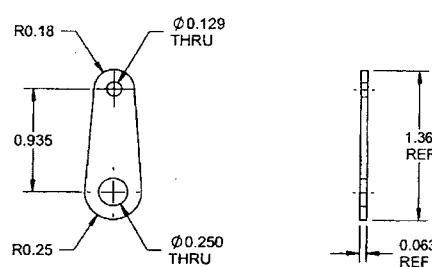
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DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	DRAWING NO. REV. C
MFG. APPR.	<i>[Signature]</i>	D3589 SHEET 7 OF 8
APPROVED	<i>[Signature]</i>	TITLE SCALE
DE APPR.	<i>[Signature]</i>	LATCH ASSEMBLY NTS
DATE	12.07.04	

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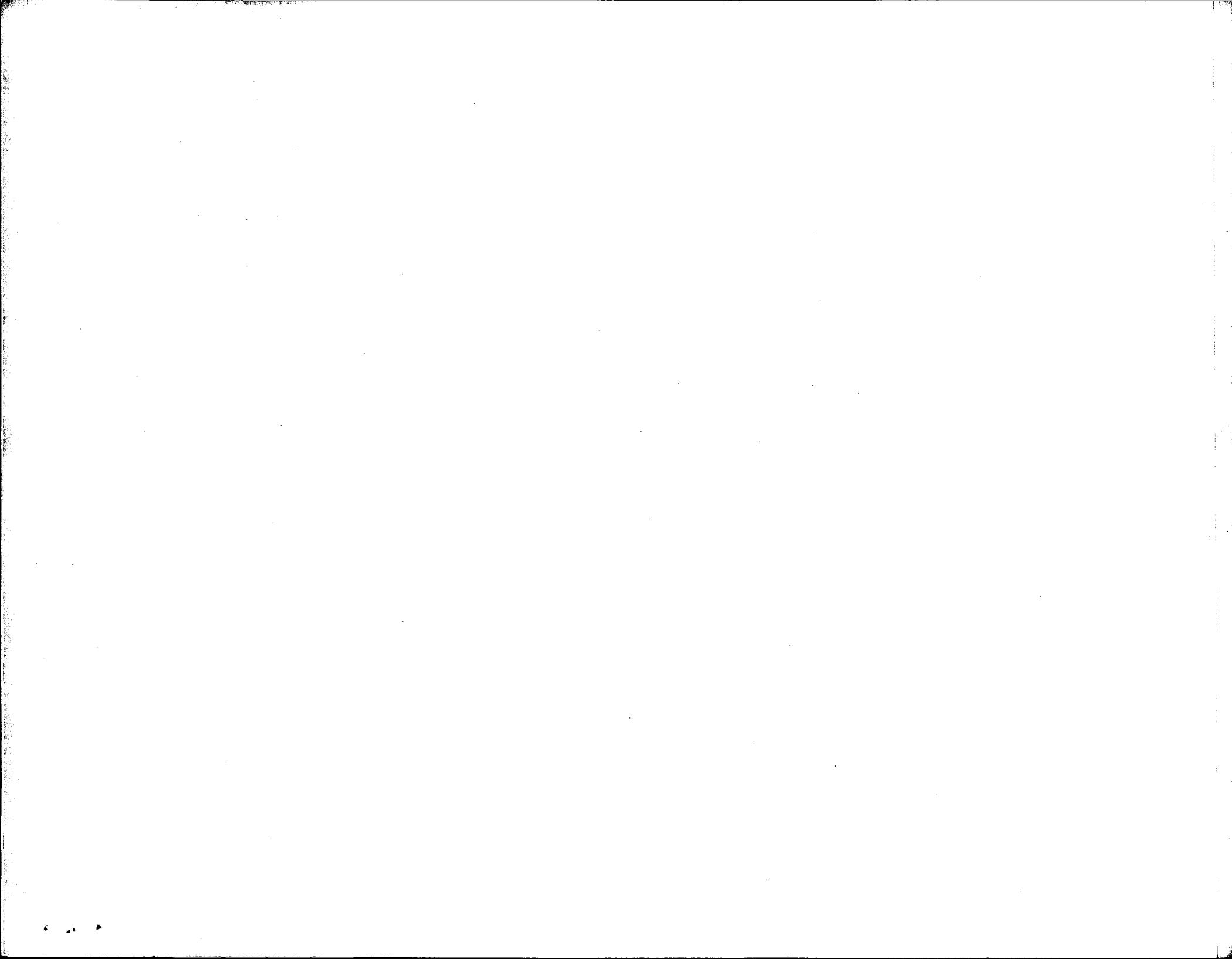
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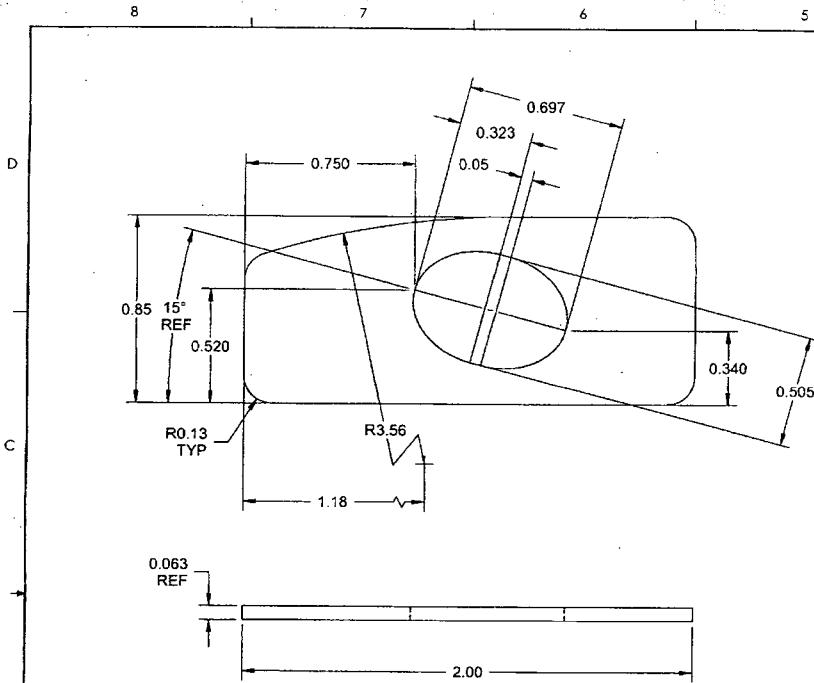
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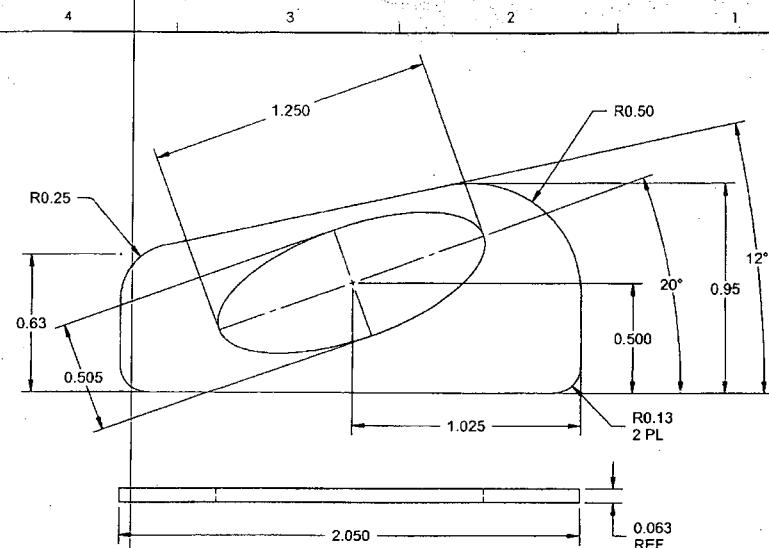
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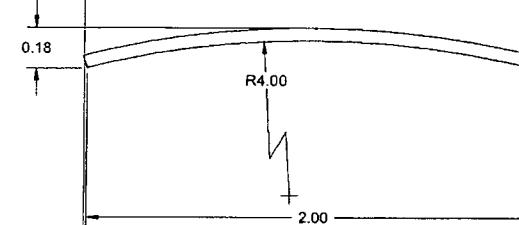




D3589-17 FORWARD GUIDE PLATE



D3589-19F AFT GUIDE PLATE FLAT PATTERN



**D3589-19 AFT GUIDE PLATE
(MAKE FROM D3589-19F)**

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DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	REV. C
MFG. APPR.	<i>[Signature]</i>	DRAWING NO. D3589
APPROVED	<i>[Signature]</i>	SHEET 8 OF 8
DE APPR.	<i>[Signature]</i>	TITLE LATCH ASSEMBLY
DATE	12.07.04	SCALE NTS

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A D3589-17-19-19F NOTES:
 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, PER AMS 5513 OR AMS 5524,
 OR MIL-S-5059 (ANNEALED) 2B FINISH
 16 GAUGE (0.063 THICK), (REF. DART SPEC M304S16GA)
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 0.02 lbs EACH

8 1 7 6 5 4 3 2 1

